

Shp 3m.1k

Work Order ID 78110

78110

December-28-11 3:35:17 PM

Item ID: D3850-1KGY Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Hat Bin-Grey
Start Date: 28/12/2011 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 16/01/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: M.C.J Date: 11/12/29 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3850	Rev C								
100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Cut sheet to required size								<u>Ph</u> 12/01/09
105		0.00							
105	Dry Material								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX								<u>Ph</u> 12/01/09
	Temp: <u>7:00 pm 150°F</u>								
	Time IN: <u>7:00 pm 12/01/08</u>								
	Time OUT: <u>5:00 am 12/01/09</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78110

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Page 2

December-28-11 3:35:17 PM

Item ID: D3850-1KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Hat Bin-Grey

Stop ***NS2***

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110									
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform as per Dwg. D3850 and folio FTA036 using tool DT 9338								
	Dwg. Rev. <u>C</u>								
	Folio Rev. <u>C</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/01/09
PTO →
12/01/09
12/01/09

W/O: 78110		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3850-1 KEY ~~D3850-1 KEY~~ PAR #: _____ Fault Category: Thermal NCR: Yes No QA Date: 12/1/23
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12/1/26 Date: 12/1/26

NCR: 12-11416		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/09	110.	FINISHED PART. BURNED TOO HOT. REASON: PROGRAM	 12.01.12 Q51042	CORRECT INFRARED SETTING. SCRAP = Replace 1 part. M11675	 12/01/09	 12/01/20	 12.01.12 Q51042	 12/01/20

NOTE: Date & initial all entries

December-28-11 3:35:17 PM

78110

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 28/12/2011 **Start Qty:** 1.00

*** 1 ***

Customer:

Required Date: 16/01/2012 **Req'd Qty:** 1.00

*** 1 ***

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____ **Date:** _____

SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78110***78110***

Page 4

December-28-11 3:35:17 PM

Item ID: D3850-1KGY

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hat Bin-Grey

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/23

1201-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-28-11 3:35:24 PM

Page 1

Work Order ID: 78110

78110

Parent Item: D3850-1KGY

D3850-1KGY

Parent Item Name: Hat Bin-Grey

Start Date: 28/12/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.125-P3-52068		Purchased	No			100	sf	566.2486	11.41	12.01053			

MKYD6185S 125-P3-52068

**

Kydex steel grey

Location

Loc Qty

Loc Code

therm

566.24858

111807

156.74858

111875

409.5

24,0210g RSH

Dk
18/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78110
Description: Hat Bin		Part Number:	D3850-1KIV/KGY
Inspection Dwg: D3850	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/8"</u>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL Date: 12/01/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.55	Min	<u>0.66</u>	✓		<u>Visual</u>	
0.055	Min	<u>0.117</u>	✓		<u>ULTRA</u>	
0.030	Min	<u>0.048</u>	✓		<u>ULTRA</u>	

Measured by: DL Date: 12/01/11
Audited by: 8 Date: 12/01/20
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ <u>JA</u>	<u>JA</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

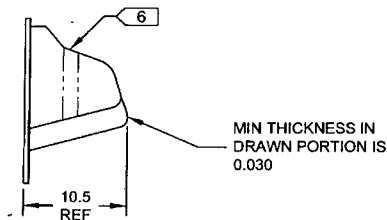
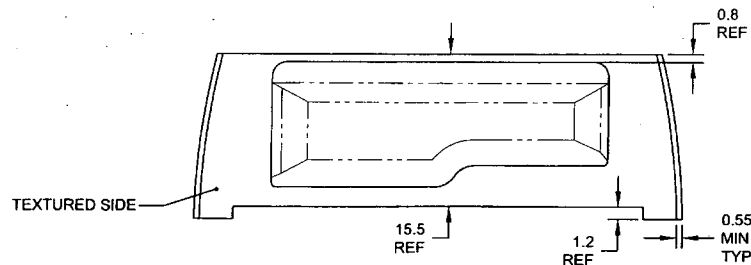
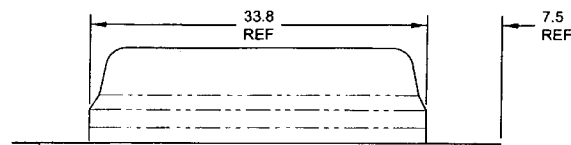
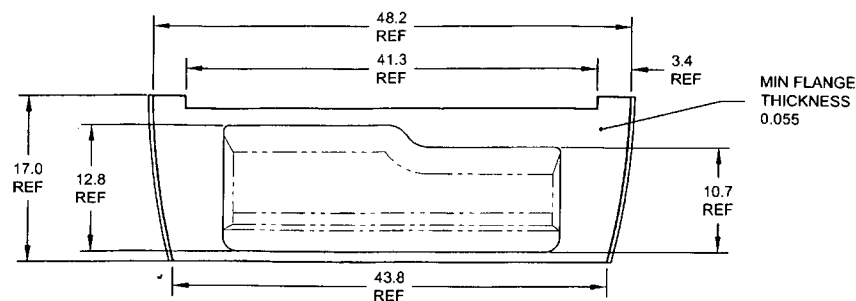
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8 7 6 5 4 3 2 1



D3850-1 HAT BIN
(BELL 206 L3/L4)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9338 PER DART QSI 022. TRIM PER MOLD

C
C

PART NUMBER	DESCRIPTION
D3850-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3850-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3850-1KIV AND ADD STEEL GRAY P/N D3850-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3850	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN (BELL 206 L3/L4)	NTS
DATE	09.05.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH AFFECT OF
WORK ORDER
NO. 78110 M.C-5
11/12/29

RELEASED
01/05/22 MHP

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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